

Work Order ID 67742

Tuesday, March 29, 2011 4:17:53 PM



Page 1

Item ID: D2896-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: ✓

Date: 11-03-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2896	Rev U/R								

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA167

Folio Rev: AA

Dwg Rev: B

0.00

0.00

11/04/26

18

Deburr

****Program Batch #*****

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

11/04/26

18

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Page 2

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Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



0.00

end 11/04/26

18

0

QC

Memo

Quality Control

130

HandFinishing

0.00



0.00

HandFinish

Memo

Hand Finishing

Mask Ø0.625" and face and bore as per Detail D and note 4 hole prior to paint

11

05

02

18

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

N/A

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Page 3

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Setup Start



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Item Name: Support

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

N/A

160



SprayPaint

Spray Painting

SprayPaint

Memo

Prime Bore as per QSI 005 4.2.

0.00

0.00

ET 11 05-04 (18)

170



QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

M 11 05 05 (18)

Work Order ID 67742

Page 4

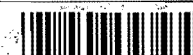
Tuesday, March 29, 2011 4:17:53 PM

Item ID: D2896-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *X tube*

0.00



Packaging

Memo

0.00

Packaging

27 11-05-05 (x18)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/5/6**MF 11-05-05*

Picklist Print

Tuesday, March 29, 2011 4:18:00 PM

Page 1

Work Order ID: 67742



Parent Item: D2896-1



Parent Item Name: Support

Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B 02.11.26 Reformat; Added P/O; Added mask hole KJ
IPP Rev: C As per Rev B 07-04-16 JLM
IPP D 08.03.19 Re-format EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK080

Manufactured

No

Each

16.0000

10



2 11/04/18

D2896-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT060

16

47929

6

58410

10

10

DART AEROSPACE LTD		Work Order:	67742
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.172	2.160	2.170	2.170	2.167
AB	2.340	2.360		2.348	2.349	2.352	2.351	2.354
AC	3.550	3.560		3.550	3.550	3.555	3.555	3.555
AD	3.770	3.790		3.775	3.775	3.777	3.777	3.780
AE	0.065 x 0.315	0.085 x 0.335		320x070	320x070	320x070	320x070	320x070
AF	1.42	1.48		1.453	1.447	1.454	1.448	1.451
AG	0.833	0.853		.843	.840	.848	.845	.849
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.262	.262	.262	.262	.262
AJ	0.189	0.194		.191	.191	.191	.191	.191
AK	1.990	2.010		2.004	2.001	2.008	2.003	2.005
AL	0.625	0.630		.626	.626	.626	.626	.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.946	.943	.944	.941	.945
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.002	.004	.001	.001	.003

Measured by: JL **Date:** 11/04/18

Audited by: [Signature] **Date:** 11/04/26

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order:	67742
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1.6	2.7	2.8	2.9	2.10
HAAS Section								
AA	2.152	2.172		2.163	2.165	2.163	2.161	2.160
AB	2.340	2.360		2.356	2.353	2.352	2.351	2.351
AC	3.550	3.560		3.555	3.555	3.555	3.556	3.555
AD	3.770	3.790		3.780	3.778	3.778	3.779	3.782
AE	0.065 x 0.315	0.085 x 0.335		3.20x0.10	3.20x0.10	3.20x0.10	3.20x0.10	3.20x0.10
AF	1.42	1.48		1.453	1.456	1.452	1.456	1.459
AG	0.833	0.853		0.848	0.851	0.844	0.846	0.846
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.262	0.262	0.262	0.262	0.262
AJ	0.189	0.194		0.191	0.191	0.191	0.191	0.191
AK	1.990	2.010		2.003	1.997	2.004	1.999	2.003
AL	0.625	0.630		0.626	0.626	0.626	0.626	0.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.944	0.946	0.940	0.942	0.942
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				0.001	0.005	0.005	0.002	0.000

Measured by:	<i>[Signature]</i>	Date:	11/04/20
Audited by:	<i>[Signature]</i>	Date:	11/04/20
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order:	67742
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

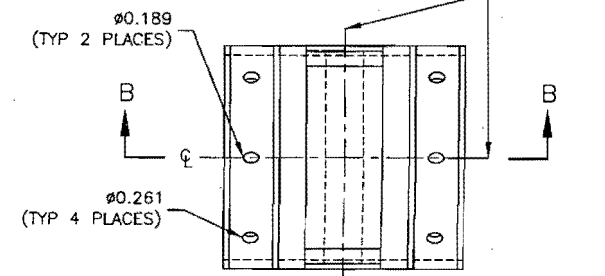
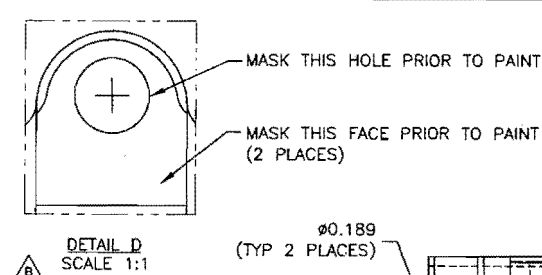
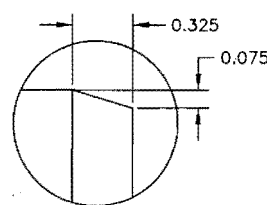
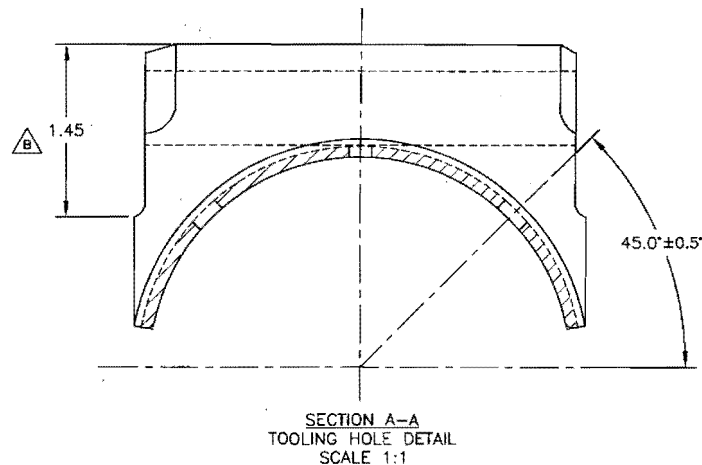
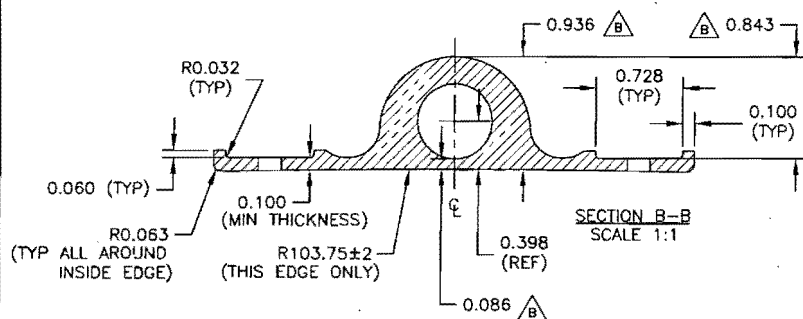
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.166	2.163	2.164	2.162	2.160
AB	2.340	2.360		2.351	2.352	2.355	2.351	2.352
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AF	1.42	1.48		1.457	1.458	1.454	1.455	1.453
AG	0.833	0.853		.849	.847	.847	.846	.847
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.262	.262	.262	.262	.262
AJ	0.189	0.194		.191	.191	.191	.191	.191
AK	1.990	2.010		2.006	2.004	2.008	1.997	2.001
AL	0.625	0.630		.626	.626	.626	.626	.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.943	.941	.943	.942	.943
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.001	.000	.004	.004	.0005

Measured by: SL **Date:** 11/04/21

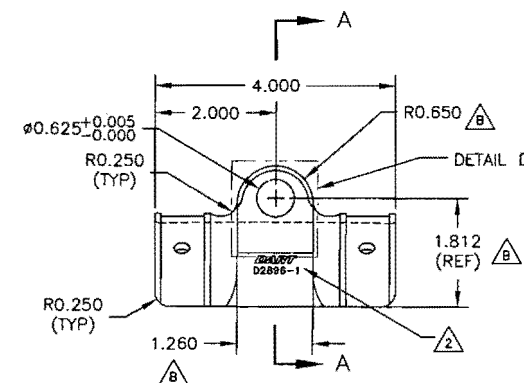
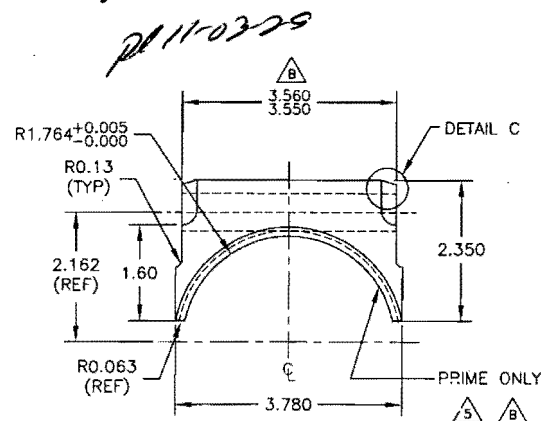
Audited by: OML **Date:** 11/04/21

Prototype Approval: **Date:**

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A	02.12.13	New Issue	KJ/RF	
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C	06.11.22	Note added to HAAS section	KJ/JLM	
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67742



D2896-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

D2896-1

UNDER REVIEW
03.03.11 PH
NO MORE POWDER
COAT

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DART AEROSPACE LTD.

B	07.03.19	INCORP. A1-A4, FINISHING NOTES
A	01.10.19	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D2896
DATE	07.03.19	TITLE SUPPORT
		REV. B SHEET 1 OF 1 SCALE 1:2